

5/07

<b>DART AEROSPACE LTD.</b>	<b>Work Order :</b>	<b>22223</b>
<b>Description:</b> 206 Saddle, Inboard, Right Side	<b>Part Number:</b>	<b>D2666-2</b>
<b>Drawing:</b> D2666 Rev. B	<b>Qty:</b>	<b>10</b>

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>HA</i>	05.01.13	10
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (D6101-001) RF 02/09/16 Batch No: <i>B20981</i>	<i>7ml</i>	05.02.16	10
3	HAAS	Program part number and batch number.	<i>7ml</i>	05.02.16	10
4	QC	Inspect part number and batch number are programmed correctly.	<i>EP</i>	05/02/16	10
5	HAAS	Fixturing W/O No. <i>N/A</i> Fixturing Inspection last completed <i>N/A</i> by <i>N/A</i>	<i>7ml</i>	05.02.16	10
6	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	<i>7ml/E</i>	05.02.18	10
7	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	<i>7ml/E</i>	05.02.18	10
8	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	<i>7ml/E</i>	05.02.18	10
9	LAGUN	Machine Keyway and inspect per attached dimension sheet	<i>7ml/E</i>	05.02.18	10
10	METAL	Deburr	<i>7ml/E</i>	05.02.18	10
11	QC	Inspect Level 1	<i>7ml/E</i>	05.02.18	10
12	QC	Inspect Level 8	<i>EP</i>	05/02/18	10
13	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>MI</i>	05.03.02	10
14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>MI</i>	05.03.03	10
15	QC	Inspect Level 3	<i>CZ</i>	05.03.09	10
16	STORES	Pack in foam, identify and stock.	<i>CZ</i>	05.03.09	10
17	EXPEDITING	Close Work Order Job Cost / Part <i>65.85 SAC 05/03/18</i> <i>(10)</i>	<i>HA</i>	05.04.26	10

(PTO)

Rev	Date	Change	Created By	Approved
A	97.07.24	New Issue		
B	98.09.08	Inspection levels, added powder coat	KS	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	

RELEASED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22223		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
1502-18	5	1 part scrap, improperly clamped. (operator error)		Scrap & replace	 05/04/26	 15-02-18	 1502-18	 1502-18

Part No: D2666-2 PAR #: \_\_\_\_\_ Fault Category: Prod/machining NCR: ☒ Yes ☐ No DQA:   
 NOTE: Date & initial all entries QA: N/C Closed:   
 Date: 05/04/26 Date: 05.04.26

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 22223
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D2666-2
<b>Inspection Dwg:</b> D2666 Rev. B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.128	0.121	0.123		
B	0.100	0.140		0.124	0.120	0.126	0.121		
C	0.100	0.140		0.134	0.130	0.117	0.119		
D	0.210	0.230		0.224	0.115	0.215	0.219		
E	1.245	1.255		1.250	1.251	1.250	1.250		
F	1.245	1.255		1.250	1.251	1.250	1.250		
G	5.990	6.010		6.000	6.000	6.006	6.000		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.680	1.679	1.679	1.679		
J	2.495	2.505		2.499	2.501	2.501	2.501		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.235	0.236	0.235	0.235		
N	0.100	0.140		0.124	0.116	0.121	0.124		
O	0.540	0.560		0.548	0.545	0.545	0.545		
P	0.490	0.510		0.507	0.502	0.502	0.501		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		0.255	0.255	0.254	0.255		
T	0.100	0.180		0.137	0.148	0.140	0.140		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.134	1.128	1.130	1.129		
W	1.565	1.585	DT8695 A/B						
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	gmk
Date:	05-02-22

Audited by:	EP
Date:	05/02/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22223</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2666-2</b>
<b>Inspection Dwg:</b> D2666 Rev. B		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.119	0.120	0.121	0.118		
B	0.100	0.140		0.124	0.124	0.123	0.122		
C	0.100	0.140		0.119	0.121	0.120	0.120		
D	0.210	0.230		0.219	0.220	0.221	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	5.990	6.010		6.000	6.001	6.002	5.999		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.679	1.680	1.681	1.680		
J	2.495	2.505		2.501	2.500	2.501	2.500		
K	0.257	0.262	DT8683	—	—	—	—		
L	0.312	0.317	DT8686	—	—	—	—		
M	0.235	0.240		0.235	0.236	0.236	0.236		
N	0.100	0.140		0.118	0.1120	0.114	0.114		
O	0.540	0.560		0.542	0.544	0.542	0.543		
P	0.490	0.510		0.501	0.500	0.501	0.501		
Q	3.609	3.619		3.612	3.612	3.611	3.613		
R	2.470	2.510		2.500	2.500	2.501	2.501		
S	0.240	0.270		0.253	0.250	0.258	0.258		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	0.313	0.318	DT8686	—	—	—	—		
V	1.125	1.145		1.132	1.132	1.134	1.134		
W	1.565	1.585	DT8695 A/B	—	—	—	—		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	05-02-18

Audited by:	<i>[Signature]</i>
Date:	05/02/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jan 13, 2005  
10:56 am

Work Order No	: 0022223	Department Code:	
Project Name	: D2666-2	Burden Flags	: NNNNNNNN
Project For	: WK507	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2666-2	Invoice Number	:
Description	: Saddle, RH, Fwd,Aft, In	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 10	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 01-13-05	Actual Margin	: 0.000%
Est Finish Date	: 02-15-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00